

Date: Monday, 11/21/2005 12:39:49 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY		
Job Number	: 24859		Part Number	: D3159043		
Estimate Number	: 10798		Drawing Number	: D3159 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 11/21/2005 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 12/21/2005 Qty: 4 Um: Each		
Previous Run	: N/A					
Written By	: SEE COMMENT Below					
Checked & Approved By	: SEE ABOVE DATE & USER.					
Comment	: Est A 02.05.13 New Issue NG					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S063	6061-T6 .063 Sheet  Comment: Qty.: 3.0391 sf(s)/Unit Total : 12.1565 sf(s) Stack of 7 Blank size: 2.560" x 1.545" x .063" thick. Grain along 1.545" Matl: 6061-T6 .063" thick  <i>7/21/06/02/19</i> <i>14</i> <i>Batch M18556</i>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1  Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA238 <i>Stack of 7</i>  <i>7/21/06/02/19</i> <i>14</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  Comment: INSPECT PARTS AS THEY COME OFF MACHINE  <i>7/21/06/02/19</i> <i>14</i>
4.0	QC8	SECOND CHECK  Comment: SECOND CHECK  <i>J.L. 06-02-19</i> <i>14</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  Comment: SMALL & MEDIUM FAB RESOURCE 1  <i>1-Deburr break all sharp edges .005 to 0.010</i> <i>SAD 06/02/26</i> <i>14</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 24859

Part Number: D3159043

Job Number:



Seq. #: Machine Or Operation:

Description :

2-C'sink holes as per Dwg D3159

SB 06/02/21

14

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per drawing (Note: -044 OPPOSITE)

SB 06/02/21

14

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAB 06/02/21

14

8.0 MS21061L06 Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nutplate

Pick:

Qty	Part number	Description	Batch
1	MS21061L06	Nutplate	M19085

9.0 MS20426AD34 RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

RIVET

Pick:

Qty	Part number	Description	Batch
2	MS20426AD3-4	Rivet	M15786

SB 06/02/23

14

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg.

SB 06/02/23

14

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-02-24

14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 12:39:49 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 24859

Part Number: D3159043

Job Number:



Seq. #:	Machine Or Operation:	Description :
12.0	PACKAGING 1	PACKAGING RESOURCE #1
	<p>Comment: PACKAGING RESOURCE #1 Identify with P/N and B/N using a permanent fine point marker, then Stock Location: <u>ST 410</u></p> <p><i>11/2/24 (14)</i></p>	
13.0	DC	DOCUMENT CONTROL
	<p>Comment: DOCUMENT CONTROL Inspection Level 21</p> <p><i>SP 060227 (14)</i></p>	

Job Completion



11/2/24 (14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

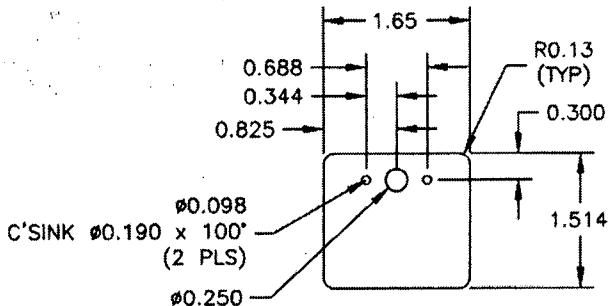
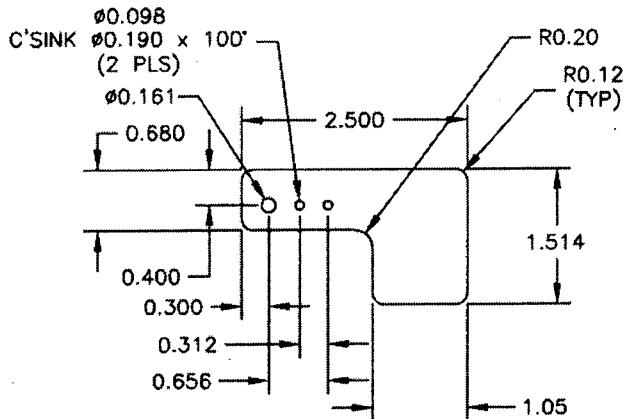
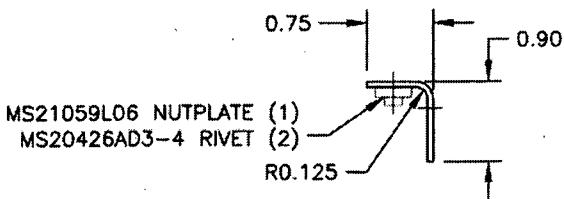
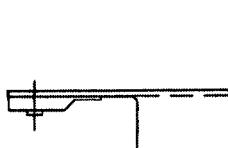
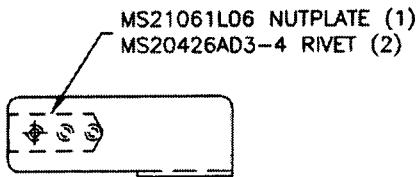
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3159	SHEET 1 OF 1
DATE		TITLE	SCALE
04.10.18		BRACKET ASSEMBLY	1:2
A	02.04.30	NEW ISSUE	
B	04.10.18	ADD PART MARKING	

RELEASED

04-11-23

D3159-1 BRACKET FLAT PATTERND3159-3/-4 BRACKET FLAT PATTERND3159-041 BRACKET ASSEMBLY

D3159-043 BRACKET ASSEMBLY (SHOWN)
REPLACES PREMIER P/N B30-23000-259
(D3159-044 BRACKET ASSEMBLY (OPPOSITE))
REPLACES PREMIER P/N B30-23000-260

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY D3159-041/-043/-044 WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No : 0024859
Project Name : D3159-043
Project For : WK551
Work Order Type : Main
Main WO Number :
House Part Number : D3159-043
Description : Bracket Assembly
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 11-17-05
Est Finish Date : 12-21-05
Act Finish Date :
Drawings Reqd : No
OK" for Approval :
Approval Rec'd :
Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss)	0.00	0.00

DART AEROSPACE LTD	Work Order:	24859
Description: BRACKET	Part Number:	D3159-3
Inspection Dwg: D3159 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	<u>9m</u>	Audited by:	<u>J.L</u>	Prototype Approval:	
Date:	<u>06/02/19</u>	Date:	<u>06.02.19</u>		Date:

Rev	Date	Change	Revised by	Approved
A	.	New Issue	KJ/RF	